

Date: Tuesday, 05/08/2008 12:57:58 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD	(6)
Job Number	: 40988	Part Number	: D35641	
Estimate Number	: 12781	Drawing Number	: D3564 REVD	
P.O. Number	:	Project Number	: N/A	
This Issue	: 05/08/2008 S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC	Material	:	
First Issue	: / /	Due Date	: 12/08/2008	Qty: 20 Um: Each
Previous Run	: 39286	Type	: SMALL /MED FAB	
Written By	:			
Checked & Approved By	: <u>MF 08-08-05</u>			
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 1.1550 sf(s)/Unit Total: 23.1000 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 108124 B 8-8-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: D
 Prog Rev: D
 2-Deburr if necessary

B 8-8-6
B 8-8-6

(22)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-8-6

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/06 22 counted

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155

S 08/08/19 (22)

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Drawing Name: WEARPAD

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Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

S 08/08/19 (x22)

counter

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M108631
Weld hardcoat as per Dwg D3437

EL 8-8-20

(6)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/20 (x6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (x6)

10.0

POWDER COATING

POWDER COATING



M106442



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:15
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:45

M.F. 08/08/21

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-21

(6x)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

24 08-08-21

x6

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40988

Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



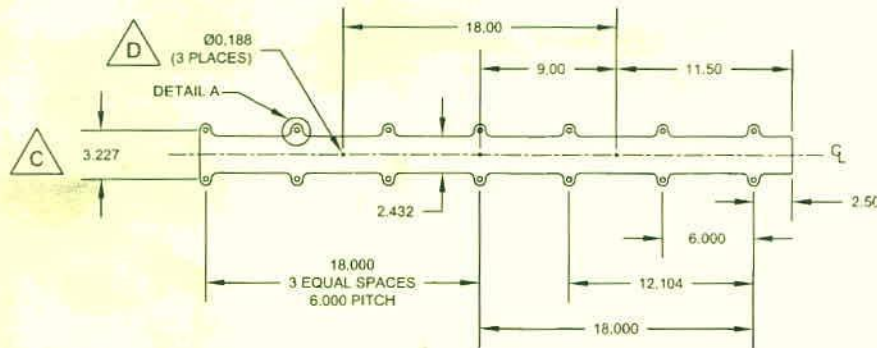
08/08/22 JF

Comment: FINAL INSPECTION/W/O RELEASE

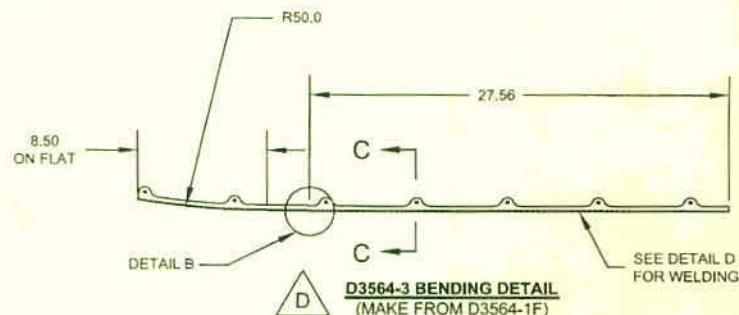
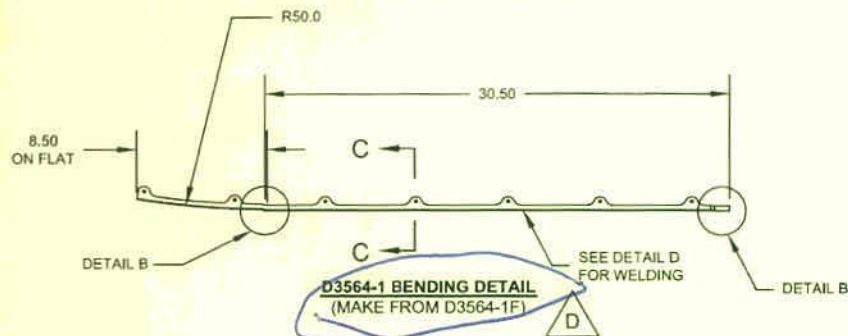
Job Completion



MF 08-08-21



D3564-1F FLAT PATTERN



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:

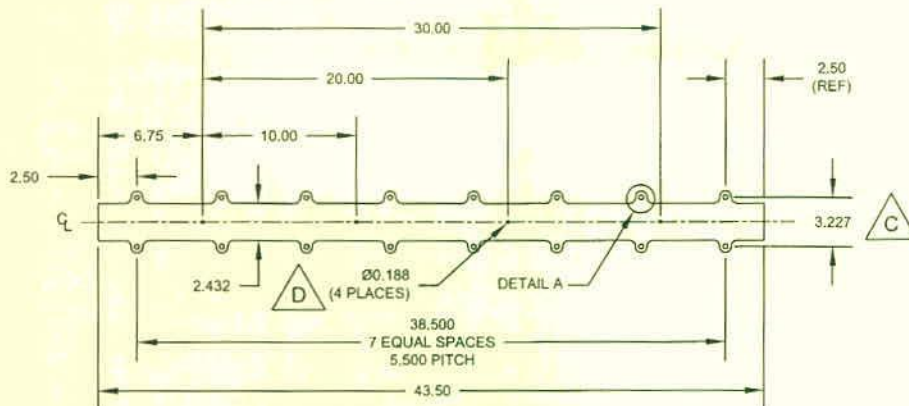
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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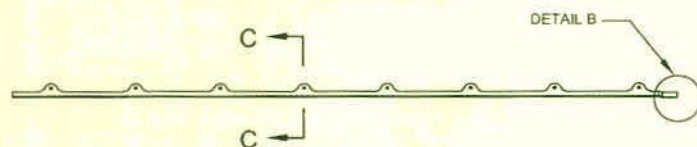
RELEASED
07.09.04

#40988

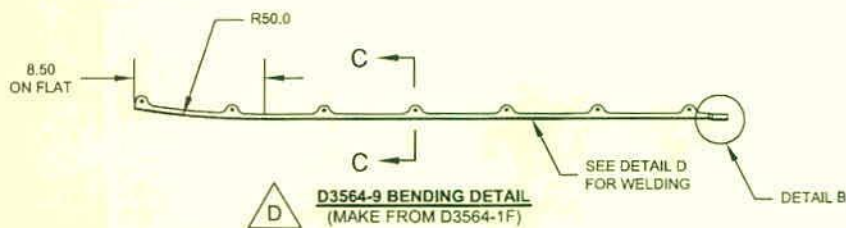
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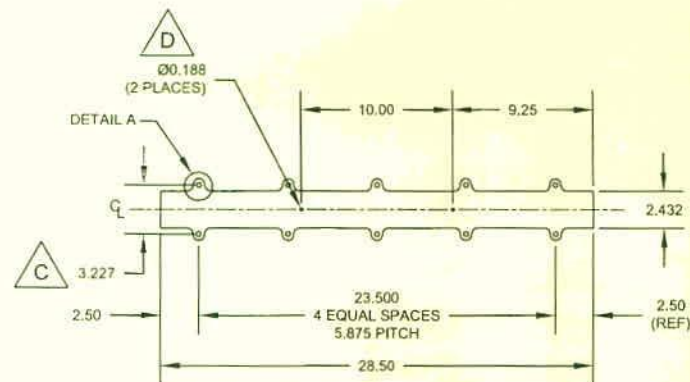
D3564-5F FLAT PATTERN



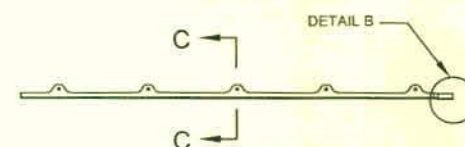
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



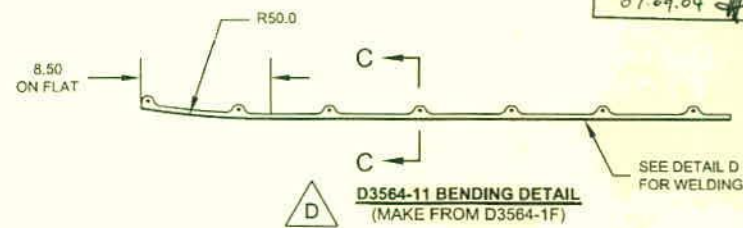
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



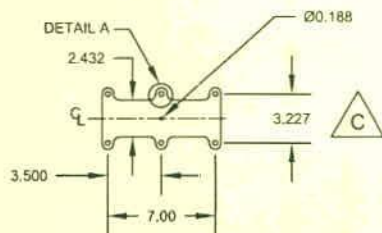
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

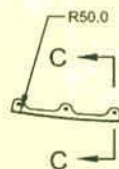
07-09-04

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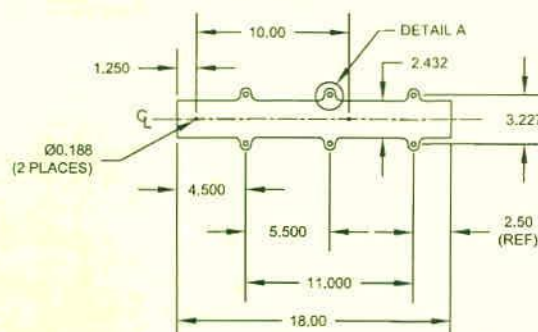
8 7 6 5 4 3 2 1



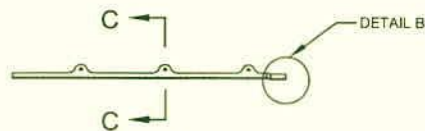
D3564-13F FLAT PATTERN



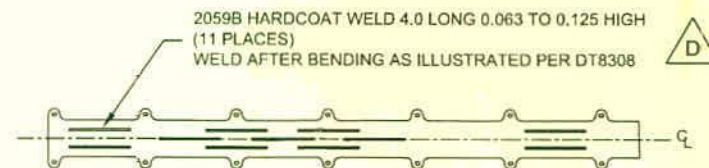
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



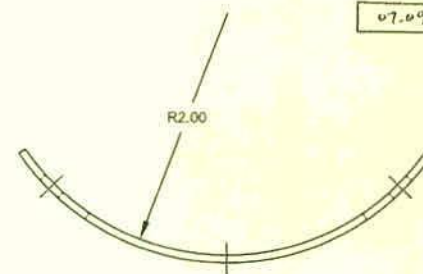
D3564-15F FLAT PATTERN



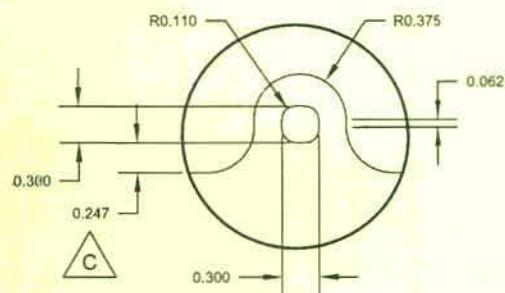
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



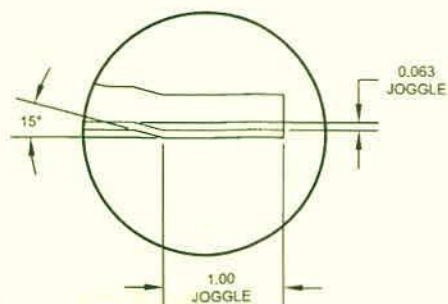
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

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